Work Order February-14-13				*970				Page 1			
Revision ID: Item Name:	D2235-1 Basket Rib	Start Ot 2 00	*4*	Accept	*N900		100)* s	Setup Sta	IV	S1* S2*
Start Date: 2 Required Date: 2 Reference:	2/14/13 2/25/13	Start Qty: 2.00 Req'd Qty: 2.00	***	(4x)	Cust Item Customer:	ID:	·				•
Approvals:	Process I	Plan: MCJ	Date: 13-02-	/S Tooling:	D	ate:		F	Run Sta Sto	1/7	R1*
	QC:		Date:	SPC (Y/N):	E	ate:			500	* *N	R2*
Sequence ID/ Work Center ID		Operation Description	45	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	R	Revision Nbr									1
D2235	R	ev B1									·
100		Large Fab		0.00				(D)	10	13-	4-11
Large Fab Large Fab			66-1 and cut as per dy n markings on tube 3-	0.00 vg D2235 using DT83022- rer deburr	nove						
*110 *110*		QC6- Inspect dimensions	s to drawing	0.00			٠	Ü	13-0	di v	DAS 09
QC Quality Control		Memo		0.00					13-0	<u> </u>	- \$\int_89

120

Identify as per dwg & Stock Location:

0.00

120 Packaging

004

Memo

0.00

Packaging

Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Engineering Skid-tube Crosstube Rework Prod. Eng. Coor. Quality Machining Small Fab Part No. Scrap Other Rec/Store/Packaging Thermoforming Finishing Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Action Sign & Description of work order update Initial Root Verification QC Inspector Qty or Non-conformance Chief Eng Description Date Date Step Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier **Training** Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced . ☐ Bending Bend Grain BOM/Route Over/Under tolerance Temperature/Cure Hardware Centre Not Concentric to O/S Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Moved Cuffs Contamination Maintenance **Positioned Wrong** Countersink Mislabeled Heat Treat Power Loss/Surge Other Misread Cut Too Short Inspection Strip in Tube Offset **Drill Holes** Ripples in Bend **Out of Calibration** Torque Waves in Extrusion Drawing

Out of Sequence

Outside Dimensions

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Ord February-14-13				*97(135*							Page 2	-
Item ID: Revision ID: Item Name:	D2235-1 Basket Rib			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date Reference:	2/14/13 : 2/25/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						•	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center I	I D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	Qt	•	Reject Number	Insp. Stamp	

0.00

Memo

Quality Control

pro4.11

NCR: Y	es / No				WORK ORDER NON-C		VFORI	MANCE / UP	DATE					
										QA	Closed:	Dat	e:	
Work Orde	r:		-		DISPOSITION			el: (AGAINST D	EPAR	RTMENT	PROCESS Water Jet	_	Engineering
Part N	lo				Rework Scrap Use-as-is		t	Skid-tube Machining noforming	Crosstube Small Fab Finishing			d. Eng. Coor. e/Packaging		Quality Other
NCR N	lo				Work Order Update			Large Fab	Composite			Supplier	<u> </u>	
Root				Descri	ption of work order update	1	nitial	1	tion	- 1	ign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	4	QC Inspector
Doc/Data													Ì	
Equip/Tooling		į											-	
Operator														
Material		1				Ì							İ	
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Other	_													
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Training														
Unapproved		<u></u>	11			<u> </u>		500%					_	
				•		AUL	T CATE	GORY						
Landi	ng Gear			f—	General		Jan-1		Г	٦	alized	Γ	٦,	Pressure/Forced
	Bending			., -	Bend	\vdash	Grain Hardwa					tolerance	_	Temperature/Cure
	Centre Not Concentric to O/S				BOM/Route	\vdash	-1	ire ion Incomplete	<u> </u>	— -	rt Incorrec	l l		Weld
	Cracks				Broken/Damaged		4	tions Incomplete/	Uncloar	_	rt Lost/Mi	ŀ	_	Wrong Stock Pulled
	Cuffs	/Crimped		<u> </u>	Burrs Contamination	\vdash	-	enance	L Concident	⊣	t Moved	331116	┙,	errong stock runed
	Heat Tre	+		<u> </u>	Countersink	\vdash	Mislab		-		sitioned V	Vrong		
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,	Ripples i	-	ilube	H	Drill Holes	\vdash	Offset		Ľ			· O - [
	—	Maves in	Extrucion	, ├-	Drawing		-{	Calibration			······································			
	····	Sequence		·	Finish		4	Sequence						
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Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

February-14-13 10:45:39 AM

Work Order ID:

97035

Parent Item:

D2235-1

Parent Item Name:

Basket Rib

Start Date: 2/14/13

Required Date: 2/25/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 08-12-01 DD verified by:EC

	_				Qty	•		
D3166-1 Manufactured No	 100	Each	19.0000	1 ,,	2	11	12-11-1	

Location	Loc Oty Loc Code	
WA	6B948ZO -	(4)
91594	5 2	
94945	1	
WA004	12	
94663	12	
WA006	1	
86807	1	-

												* ,
										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-	-COI	NFORM	MANCE / UPD	ATE	QA Closed:	Date:	
DISPOSITION AGAINST DEPARTMENT/PROCESS												
Work Order: Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update		Initial	Acti	Action			
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	Description		Verification	QC Inspector
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Landin	a Goar				General	1 70.	LICAIL	JOKI	 			· -
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ŀ	Cracks				Broken/Damaged		₹	ion Incomplete		Part Incorre	ct	Weld
F	Crushed/	Crimped			Burrs		Instruct	tions Incomplete/U	Inclear	Part Lost/M	issing	Wrong Stock Pulled
ľ	Cuffs	•			Contamination		Mainte	enance		Part Moved		
	Heat Tre	at			Countersink		Mislabe	eled		Positioned \	Wrong	,
	Inspection		Tube		Cut Too Short		Misrea	d		Power Loss,	/Surge	Other
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	Torque V	Vaves in I	Extrusio	n [Drawing	Ŀ	Out of	Calibration				
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D2235

SHEET 1 OF 1

